

Date: Monday, 11/21/2005 12:35:58 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER
 Job Number : 24897
 Estimate Number : 10827
 P.O. Number : N/A Part Number : D2877
 This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D2877 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : NOTE:1 BLANK MAKES 4 PARTS
 Written By : See comment below Due Date : 12/15/2005 Qty: 120 Um: Each
 Checked & Approved By : See comment below
 Comment : Est B 00.05.19 Added inspect level 8 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S100 5052-H32 .100 Sheet



Comment: Qty.: 0.5468 sf(s)/Unit Total : 65.6208 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick
 Batch: MISS30

EP 05/12/12

AdS
542

2.0 SHEAR SHEAR



Comment: SHEAR
 1 blank makes 4 parts
 Blank: 7.00" x 4.25" (+0.030" - 0.000")

EP 05/12/12 160

40 Blanks.

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2877

SA 05.12.13 120

P10

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05.12.13 120

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SG 05.12.14

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble
 Deburr any rough edges after tumbling

EL 05/12/20 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 05/12/22 120

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 05/12/22 120

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 387

LC 5/12/22 (120)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/03 (120)

SD 06/01/03 (120)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

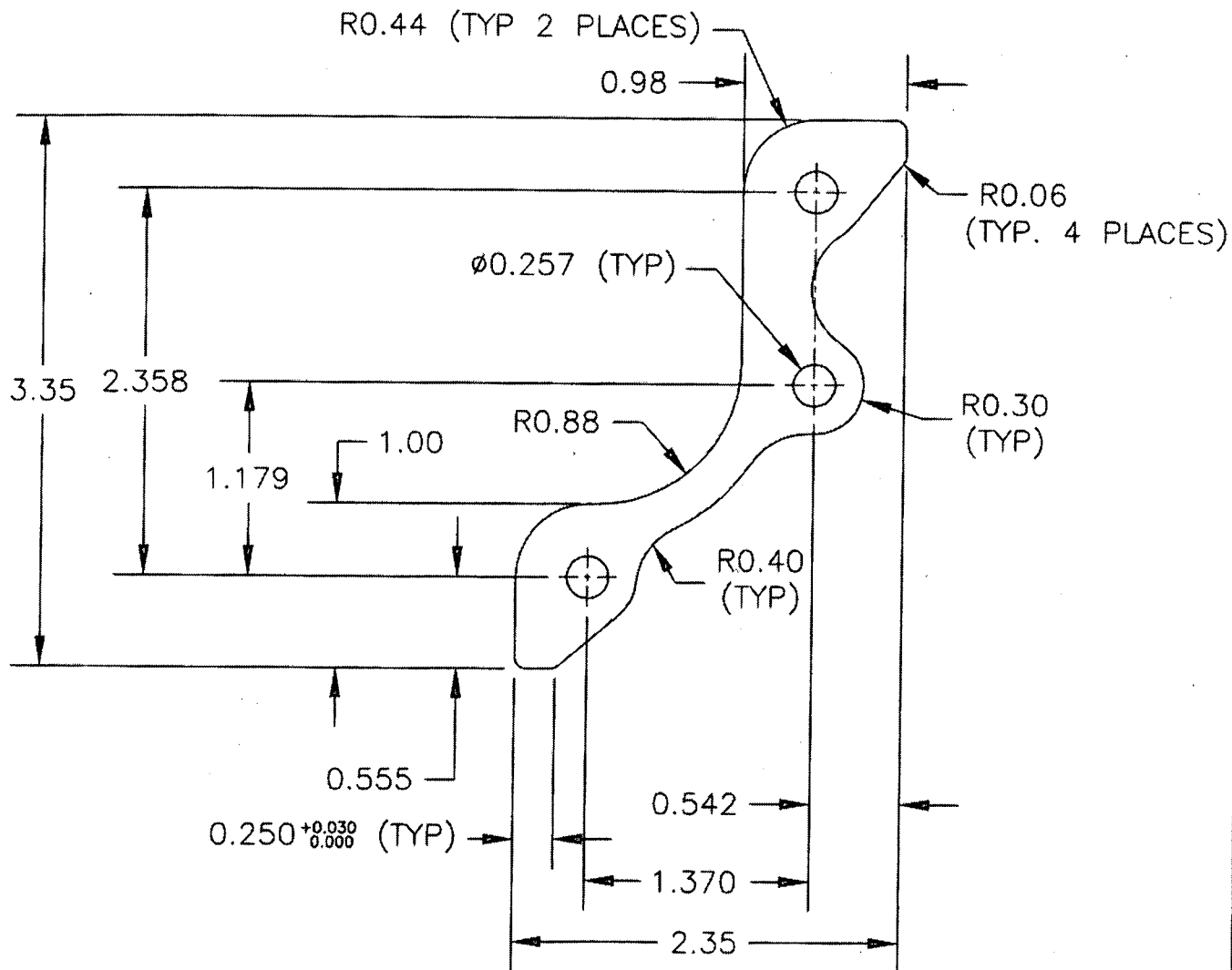
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	3.0	-10 blanks scrap. KTF drill clogged so holes are too big.		change KTF (done) Scrap: destroy - No replace Qty blanks cut was over Qty required.	SA 05.12.13	2 05.12.13		2 05.12.13

NOTE: Date & initial all entries



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DA</i>	APPROVED	<i>JS</i>	DRAWING NO. D2877
DATE	99.02.23	TITLE	SADDLE SPACER	REV. A SHEET 1 OF 1 SCALE 1:1
A	99.02.23	NEW ISSUE		

RELEASED
99.04.27 DS



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	: 0024897	Department Code	:
Project Name	: D2877	Burden Flags	: NNNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2877	Invoice Number	:
Description	: Saddle Spacer	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 120	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-18-05		
Est Finish Date	: 12-15-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00